

675-04

Dart Aerospace Ltd.

Date: Tuesday, 06/05/2008 8:54:59 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	A119 STEP WELDMENT LH
<b>Job Number</b> :	39067A		
<b>Estimate Number</b> :	10122		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3043041
<b>This Issue</b> :	06/05/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3043 REV A
<b>First Issue</b> :	///	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	36578A	<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	
	LARGE FAB ASSY	<b>Due Date</b> :	30/05/2008
<b>Written By</b> :		<b>Qty:</b>	5 Um: Each
<b>Checked &amp; Approved By</b> :	JLD 08.5.08		
<b>Comment</b> :	Est Rev :A New Issue JLM 05-11-01		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Step Extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
 Pick: D2622-120 extrusion  
 Batch: 337754

*08.05.06*

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G

2-Deburr and bevel ends for welding

*08.05.07*  
*08.05.07*

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

*08.05.07 (x5)*

4.0	D2734	Step End Plate
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 Pick:  
 Qty Part Number Description Batch  
 2 D2734 End Cap 336520

*08.05.08*

5.0	D30401	Mounting Lug
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 Pick:  
 Qty Part Number Description Batch  
 2 D3040-1 Mounting Lug 333896

*08.05.08*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 06/05/2008 8:54:59 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT LH

Job Number: 39067A

Part Number: D3043041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D30403

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3040-3 Mounting Lug 835976

08.05.08 5

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8802

AR AL ROD Batch: 1106834  
1107678

2-Grind Fwd End Cap weld flush

08.05.08 5  
08.05.12 5

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 03.05.12 5

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.05.12 (XSLH)

10.0

HAND FINISHING 1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

08.05.12 5

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043

AR AL ROD Batch: 1106834

2-Inspect for foreign object as per QSI 024

3-Grind Fwd End Cap weld flush

08.05.13 5  
08.05.13 5  
08.05.13 5

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

Date: Tuesday, 06/05/2008 8:54:59 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT LH

Job Number: 39067A

Part Number: D3043041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

MD 08/05/14 (5)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MD 08/05/14 (5) SLH

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Touch up Chemical Conversion Coat as per QSI 005 4.1

FL 08/05/14 (5)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect alodine

M/L 08/05/14

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

7:18 am

OVEN TEMPERATURE:

320 °F

FINISH TIME:

7:48 am

M/L 08/05/15

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Wing Walk as per Dwg D3043 and QSI 005 4.4

M/107892

M/L 08/05/15

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SK/BB

SP (5)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

Date: Tuesday, 06/05/2008 8:54:59 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT LH

Job Number: 39067A

Part Number: D3043041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

RPD 39067

8/5/22

SD (SX)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/23

Job Completion



MF 08-05-22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3043	REV. A SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

**PARTS LIST:**

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

**NOTES:**

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP  
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
01.07.05

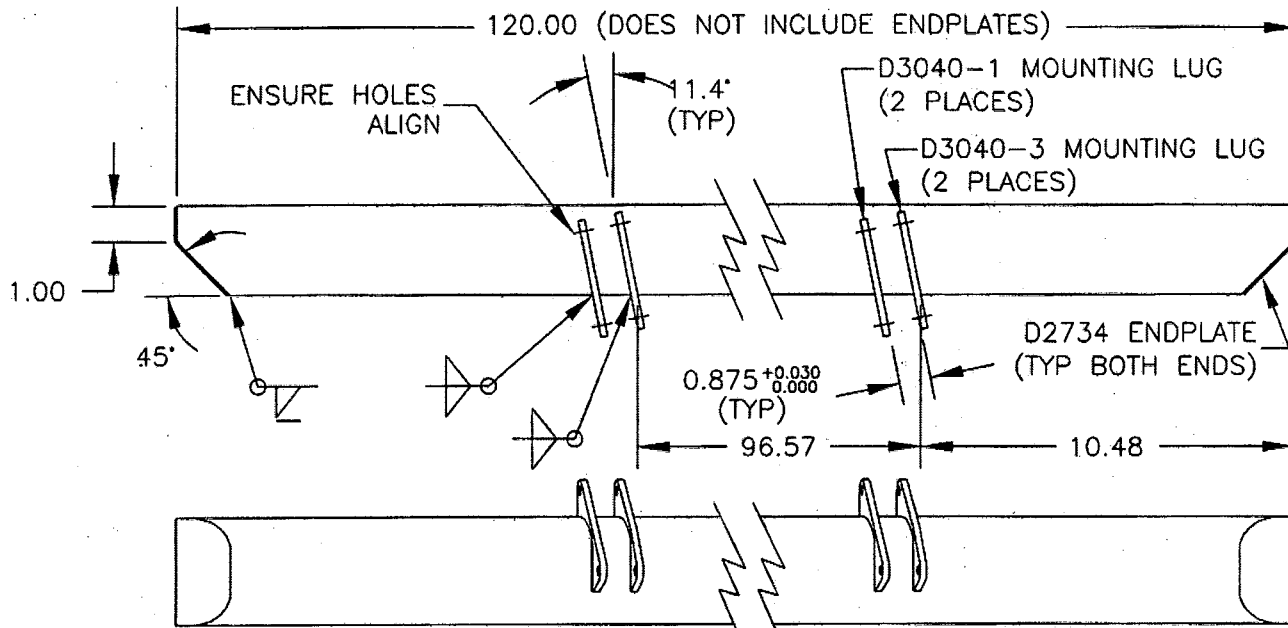
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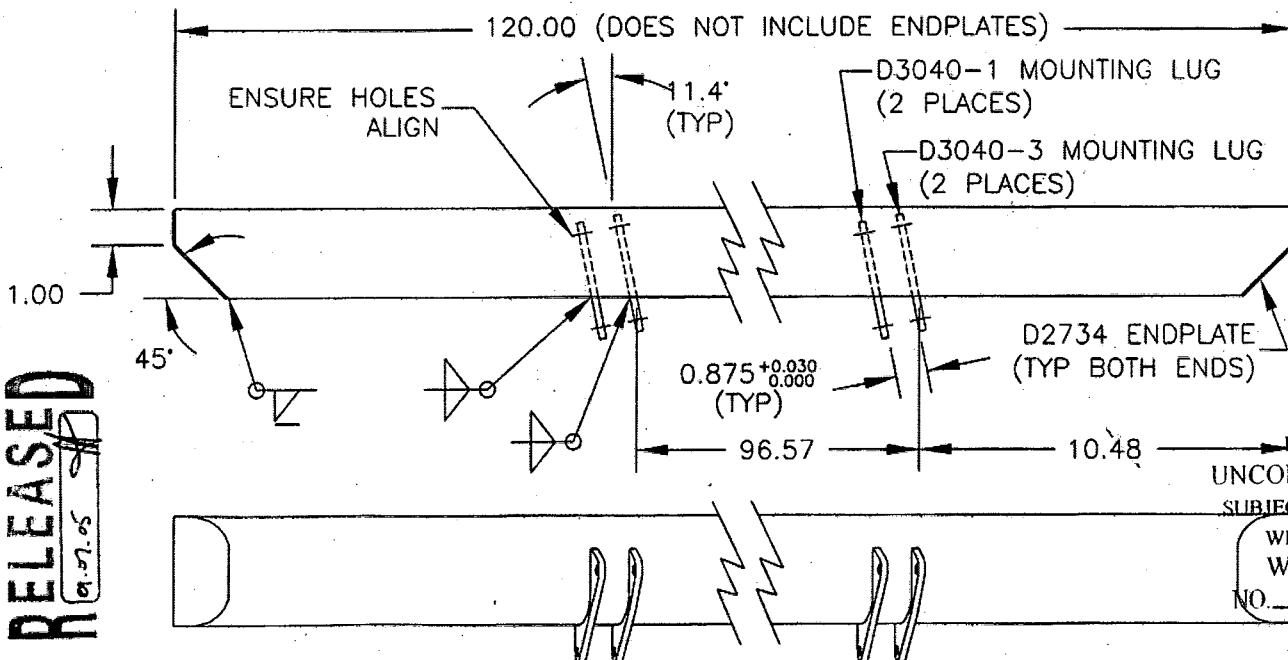
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CHECKED #	APPROVED #	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

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